

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017586**Date Inspected:** 17-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower and OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

Bay 11

This QA Inspector randomly observed the following work in progress in Bay 11:

FCAW welding of weld joint BK004A2-017-003 located on PCMK OBG BK004-017, edge plate to bottom plate. Welder was identified as 040759. QC was identified as ZPMC CWI Fu Guo Gang (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Zhao Mao Mao (QCA1), who was not a CWI. Welding variables recorded by QCA1 appeared to comply with WPS-B-T-2131.

Bay 10

This QA Inspector randomly observed no welding related work in progress in Bay 10.

OBG Trial Assembly Area

This QA Inspector randomly observed the following work in progress in the OBG Trial Assembly Area:

SMAW repair welding of weld joint TR1E-PP086-010 located on traveler rail bracket. Welder was identified as 062935. QC was identified as ZPMC CWI Liu Hua Jie (QC2). Welding variables recorded by QC2 appeared to comply with WPS-345-SMAW-2G(2F)-FCM-repair-1, WPS-345-SMAW-3G(3F)-FCM-repair-1. QC2 informed this QA Inspector that this welding was the result of ZPMC visual testing (VT).

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SMAW repair welding of the ends of deck plate I stiffeners located on the west end of CB13. Welders were identified as 044504, 040270. QC was identified as QC2. Welding variables recorded by QC2 appeared to comply with WPS-345-SMAW-2G(2F)-FCM-repair-1, WPS-345-SMAW-3G(3F)-FCM-repair-1 as identified on ZPMC Weld Repair Report B-CWR1958. The reason for repair was displayed on the report as “poor cutting of ends”.

Heavy Dock

This QA Inspector randomly observed the following on the Heavy Dock:

All 4 towers, lift 4 were positioned on a base separate pedestal at end of the Heavy Dock. South tower, lift 3 was positioned horizontally on stanchions on the deck at the end of the Heavy Dock. No work was being performed on any of the tower components and no ZPMC floating cranes were moored to the Heavy Dock or in the area.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Micheal Ng, 159-2184-5703, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet, George	Quality Assurance Inspector
Reviewed By:	Clifford, William	QA Reviewer
